

**AMENDMENTS TO THE CLAIMS, COMPLETE LISTING OF CLAIMS**  
**IN ASCENDING ORDER WITH STATUS INDICATOR**

Please cancel claims 1-4 without prejudice or disclaimer, and add the following new claims as shown.

Claims 1-4 (Canceled).

5. (New) A roll stock apparatus comprising:

a turn-table,

a plurality of process rolls standing obliquely in a circumferential arrangement in one stage or two stages at a roll pallet, said roll pallet being located on the turn-table,

wherein a longitudinal direction of the process rolls coincides with a generatrix at a conical surface, and

wherein said roll pallet can be stopped at a predetermined position to store or take out the process rolls against the roll pallet.

6. (New) The roll stock apparatus according to claim 5, wherein the roll pallet comprises a lower and upper supporting member each having two flat surfaces for supporting a lower and upper end of said process roll respectively, when said process roll stands obliquely,

wherein the lower supporting member comprises a supporting plate for supporting the lower end surface of said process roll and preventing said process roll from slipping away from the lower supporting member, and

wherein the upper supporting member, engaged with the upper end of said process roll, comprises an elongated double-surface member having a horizontal section with an obtuse angle to each other,

wherein, as the length of said process roll is decreased, the inclination of said process roll is increased to cause a distance in a horizontal direction between the center of gravity and the lower end of said process roll to change, and

wherein, even if a centrifugal force is applied to the process roll due to the rotation of the turn-table, it rises in an upright direction and it is not fallen more outwardly.

7. (New) A plating factory for a process roll in gravure printing, said factory comprising:

a plating line facility having a copper sulphate plating device or a chromium plating device or a nickel plating device or a zinc plating device for use in plating a process roll,

an industrial robot having a robot hand adjacent to one end of a line of the plating line facility to chuck the process roll at both its ends to enable the handling of the roll to be carried out,

a handling area of said industrial robot,

one or more of the roll stock apparatus according to claim 5,

wherein the industrial robot (1) takes out the process roll stored at said roll stock apparatus, (2) delivers the process roll to a roll handling means in the plating line facility, (3) additionally receives the process roll from said roll handling means in the plating line facility and (4) stores said process roll at the roll stock apparatus.

8. (New) The plating factory for a process roll in gravure printing according to claim 7, wherein a grinder stone grinding device is installed at a location near the industrial robot in said plating line facility or outside said plating line facility.